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WELDING ELECTRODE FOR ALUMINUM SHEETS

ABSTRACT OF THE DISCLOSURE

A design of a copper welding electrode is disclosed. The electrode can be used in successive spot welding operations on assembled aluminum alloy sheet parts of widely varying thicknesses, e.g., from 0.9 to 4+ mm. The electrode has a round body terminating in a truncated cone with a crowned face. The face has a diameter of about eleven millimeters up to the diameter of the body and the radius of the crowned face is about twenty to thirty five millimeters. The dimensions and shape of the electrode provide robust welding performances despite varying part thicknesses and off angle electrode positioning, and the textured surface provides good electrical contact.